

2 of 14
12.11.07

92612

November-05-12 9:05:00 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/05/12 **Start Qty:** 2.00

2

Required Date: 11/12/12 **Req'd Qty:** 2.00

2

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

140

OC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 92612

92612

Page 3

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish QC7 Memo	0.00 0.00				2	0		DAS 23 09 PTO
170 *170* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 122358 Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remainig end cap as per Dwg D4308 3-Grind end cap weld flush as per dwg D2841 4- install rivert as per dwg	0.00 0.00				2	0		K 12.11.08
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				2	12.11.9		DAS 09 08

33

change step 160 To Qc 7 For blade inspection

D45
23
89

Work Order ID 92612

92612

Page 4

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190						2	12-11-9		DAS 09 9-89
QC	Memo	0.00							
Quality Control									
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200						2	NA	12-11-9	
HandFinish	Memo	0.00							
Hand Finishing									
205		0.00							
205						2			DAS 05 9-89
SprayPaint	Memo	0.00							12-11-12
Spray Painting	PRIME B 117319 DELFLEET BLUE B 123253 DELFLEET CLEAR B 118093								

05

05

Work Order ID 92612

92612

Page 5

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
212	QC14- Inspect Spray Paint	0.00							
212									
QC	Memo	0.00							
Quality Control									
215	Wing Walk as per dwg QS1005 4.4 Batch 122589	0.00							
215									
HandFinish	Memo	0.00							
Hand Finishing									
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									

DA 16 12/11/13

42
PRV

2 6 12/11-13

x2R11 d 12/11/13

Work Order ID 92612

92612

Page 6

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location	0.00							
230						2x			Sp
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

12/11/14

ME
12-11-13

Picklist Print

November-05-12 9:05:00 AM

Page 1

Work Order ID: 92612

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

Start Date: 11/05/12

Required Date: 11/12/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	165.2300	0.05	0.1		12.01.07	

Location Loc Qty Loc Code

HALL 16.37

46910 2

64409 6

66970 7.7

68293 0.25

72131 0.42

WA 139.5

81507 1.88

83894 12.38

88513 11.24

89750 114

WA013 9.36

75781 2

77612 7.36

D2734

Step End Plate

Manufactured No

120

Each

153.0000

1

2

12.11.07

Location Loc Qty Loc Code

WA 153

80682 6

84563 10

88714 32

91761 105

2

Picklist Print

November-05-12 9:05:00 AM

Page 2

Work Order ID: 92612

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

Start Date: 11/05/12

Required Date: 11/12/12

Start Qty: 2.00

Required Qty: 2.00

D2734
Step End Plate

Manufactured No

170 Each 153.0000

1 2

12.11.07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	153	
80682	6	
84563	10	
88714	32	
91761	105	

D3458-1
Step Mounting Plate

Manufactured No

120 Each 16.0000

1 2

12.11.07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	13	
85693	13	
WA002	2	
75609	2	
WA018	1	
63075	1	

D3458-3
Step Mounting Plate

Manufactured No

120 Each 9.0000

1 2

12.11.07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	8	
82116	8	
WA002	1	
75610	1	

MS20601-AD4W2
Rivet

Purchased No

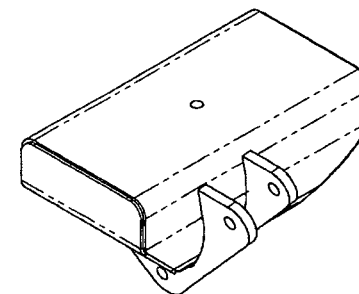
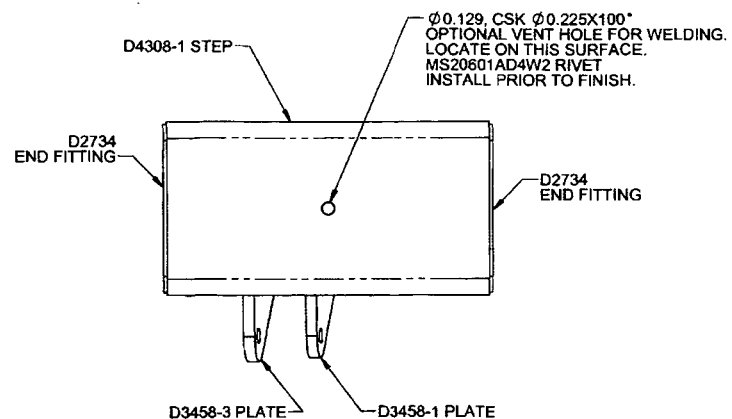
170 Each 64.0000

1 2

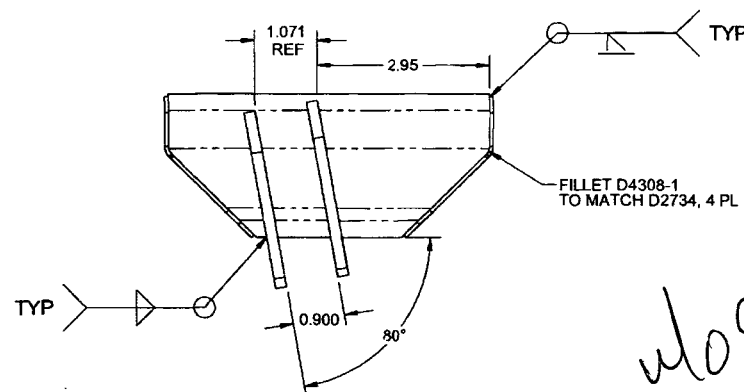
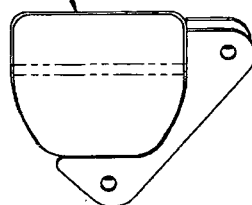
12.11.14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST311	64	
122539	64	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

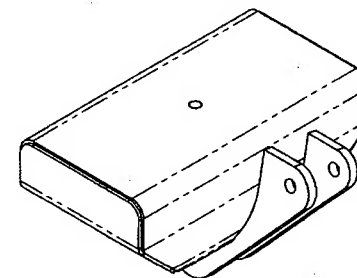
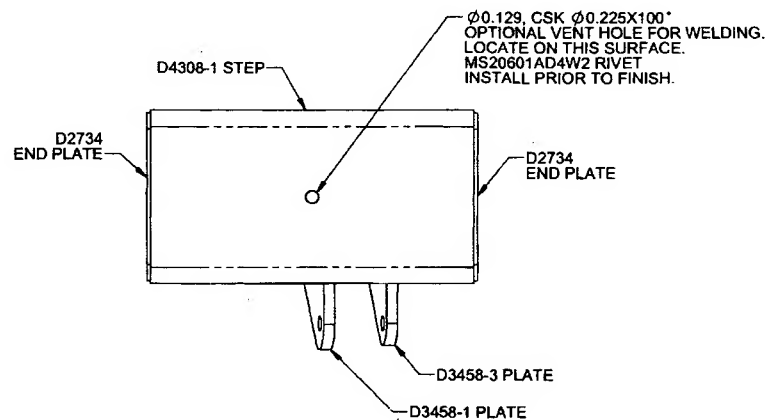
REV.	NEW ISSUE	DESCRIPTION	CP	10.12.17
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.12.17			

RELEASED
2011-05-26

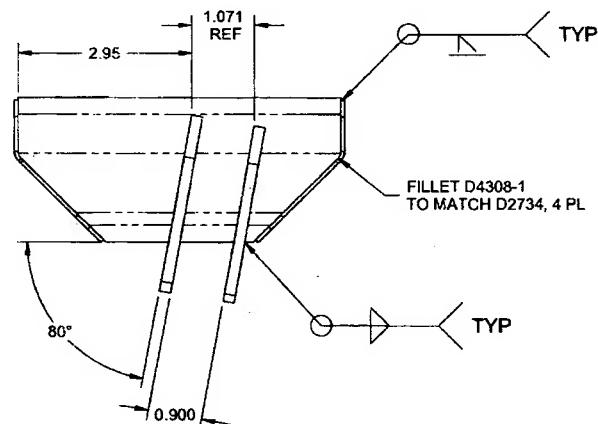
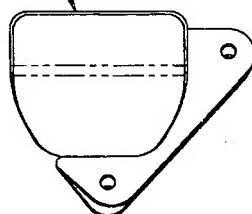
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4308**
REV. A
SHEET 1 OF 3
TITLE **STEP, CREW**
SCALE
NTS

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ITEM	QTY	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-042 STEP, RH CREW

NOTES:

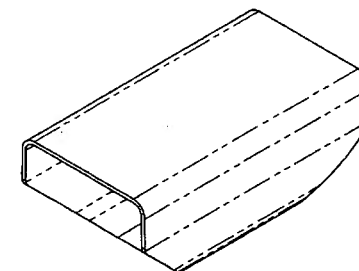
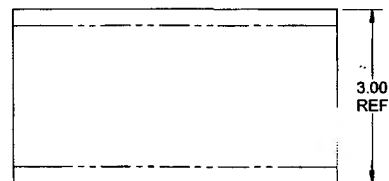
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
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2011-05-24

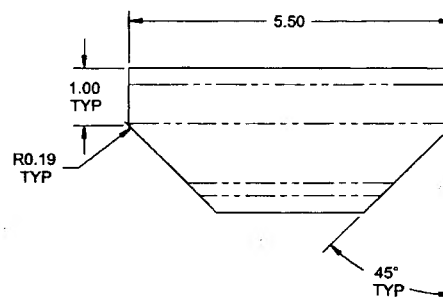
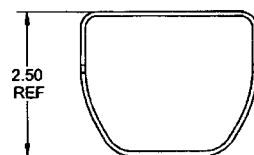
8 7 6 5 4 3 2 1

D



D

C



C

B

D4308-1 STEP

B

RELEASED
2011-05-20
JMD

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JMD</i>	D4308	SHEET 3 OF 3
APPROVED	<i>JMD</i>	TITLE	SCALE
DE APPR.	<i>JMD</i>	STEP, CREW	NTS
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A

8 7 6 5 4 3 2 1

